

Amendments to the Specification:

Page 3, lines 15-28, replace the paragraph with the following:

Integrally formed to clamping ring segment 14 of clamping ring 12 are a pair of ring guides 26 and 28. Likewise, integrally formed in semi-circular segment 14 of clamping ring 13 are ring guides 30 and 32. Ring guides 34 and 35 are each integrally formed in semi-circular segment 16 of clamping ring 12. Ring guides 36 and 38 are also integrally formed in semi-circular ring segment 16 of clamping ring 13. The ring guides 36, 38, 30, 32, 34, 36 and 38 each include a longitudinally extending bore as at 40. Fitted into longitudinal bore 40 of ring guides 26 and 30 is a first guide shaft 42 comprising a smooth, cylindrical steel rod. An identical guide shaft 44 extends between ring guides 28 and 32. Set screws, as at 46, secure guides shafts 42 and 44 in their respective bores 40. Guide shaft 48 extends between ring guide 34 and ring guide 36. Setscrews 46 secure guide shaft 48 into the longitudinally extending bore 40 of ring guides 34 and 36. A final guide shaft 50 extends between ring guides 35 and 38, and setscrews 46 secure guide shaft 50 into the longitudinally extending bore 40.

Page 3, line 29 thru Page 4, line17, replace the paragraph with the following:

A clamshell assembly 52 is slidably supported along guide shafts 42, 44, 48 and 50. This clamshell assembly may be of the type more particularly described in my earlier U.S. Patent No. 5,549,024, the teachings of which are hereby incorporated by reference as it is set forth in full herein. As explained in the '024 patent, the split frame clamshell assembly 52 includes a stationary ring member 54. Disposed beneath a protective shroud 56 and journaled for rotation on bearings (not shown) which extend in the axial direction from the flat side surface of the stationary ring 54 is a movable gear ring 58 only a small portion of which can be seen through an opening formed in the protective shroud 56 in Figure 3. This movable gear ring is adapted to be driven by a suitable motor (not shown). The manner which the motor is configured to drive the rotatable gear ring 58 of the clamshell assembly 52 is fully disclosed in the afore-referenced '024 patent. The split

ring clamshell comprises two semi-circular segments 60 and 62 that join together along a parting line 64 and may be securely clamped together by swing bolts 65. Integrally formed to the exterior side surface of the stationary clamshell ring 54 are four clamshell guide member 68, 70, 72 and 74. These guide members each include a longitudinal bore, as at 76, for receiving linear bearings 78, the linear bearings surrounding guide shafts 42, 44, 48 and 50. A cutting tool carrier 80 is attached to the movable ring gear 58 and machines the work piece as explained in the '024 patent.

Page 4, line 18 through Page 5, line 5, replace the paragraph with the following:

As shown in Figure 2 a drive assembly generally designated by 86 is integrated with the first clamping ring 12. The drive assembly 86 imparts controlled transitional movement of the clamshell assembly 52 along the guide shafts 42, 44, 48 and 50 between the clamping rings 12 and 13. The first clamping ring 12 comprises a stationary ring 88 adapted to be clamped to the cylindrical work piece and a rotatable ring 90 which is journaled for rotation on the stationary ring 88, wherein the rotatable ring 90 has a plurality of gear teeth 92 (Fig. 3) on its peripheral surface. A ~~servo~~, two-speed servo gear box 93 is mounted on the stationary ring 88. An output shaft 94 extends from a drive motor 95 with a pair of drive gears 96 mounted on the output shaft 94. The gearbox further including a spur gear 98 which is mounted on a spur gear axle 100 and secured on the axle by a bushing hex nut 102. The drive gears 96, and the spur gear 98 form a gear train which engages the gear teeth 92 on the peripheral surface of the rotatable ring 90. The gear train effects a speed reduction between the drive motor speed and the speed at which the rotatable ring is driven. The gear teeth 92 on the rotatable ring 90 engage a pinion gear 108. The pinion gear is mounted on a pinion gear axle 110 which are embedded in ring guides 28 and 34. The bushing 112 is pressed in the drive gear cover (not shown), which holds the gear 108 and shaft 110 in place.

Page 5, lines 12-15, replace the paragraph with the following:

Disposed on the clamshell assembly 52 and surrounding the feed screw 116 and 117 are feed nuts 120. The feed nuts 120 engage the clamshell drive assembly 52 and

rotation of the feed screws will translate the clamshell drive assembly 52 along the guide shafts 42, 44, 48 and 50 between the clamping rings 12 and 13.

Page 5, line 16-19, replace the paragraph with the following:

Once the clamshell assembly 52 has completed a pass down the workpiece during its cutting stroke at a low speed, it is returned to the starting position by first pressing a “reverse” switch on the servo motor 95 and shifting the two speed gear box 93 to its “fast” state by moving the larger diameter spur gear 116 into engagement with the spur gear 98 for a quick return of the clamshell assembly 52.